

Date: Wednesday, 12/5/2007 8:02:03 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 36111	
Estimate Number : 12786	
P.O. Number : <i>N/A</i>	Part Number : D35645
This Issue : 12/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3564 REVD
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 34806	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/20/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-03-08 ec	
Est Rev:B As per Rev C 07-07-09 JLM	
Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



*244178*



Comment: Qty.: 1.1099 sf(s)/Unit Total : 22.1970 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: *105997* *1B07-12-7*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3564  
Dwg Rev: *D* *1B07-12-7*  
Prog Rev: *D*

*(22)*

2-Deburr if necessary *1B07-12-7*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*1B07-12-7*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*6* *7/12/07* *(22)* *counts*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary  
Form on Brake as per Dwg D3564 using Jigs DT and DT

*3179* *8155*

Form Joggle as per Dwg D3564 on brake using Jig DT *8157*

*SB* *07/12/10* *(22)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 9/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:02:03 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 36111

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

*Handwritten:* J. Allen (x22) counts

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*Handwritten:* 07-12-11 (x22)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* m.f. 07/12/12 (22X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten:* FP-18

*Handwritten:* m.f. 07/12/12 (22X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 07/12/12 (22)

Job Completion



*Handwritten:* 07.12.12

**Dart Aerospace Ltd**

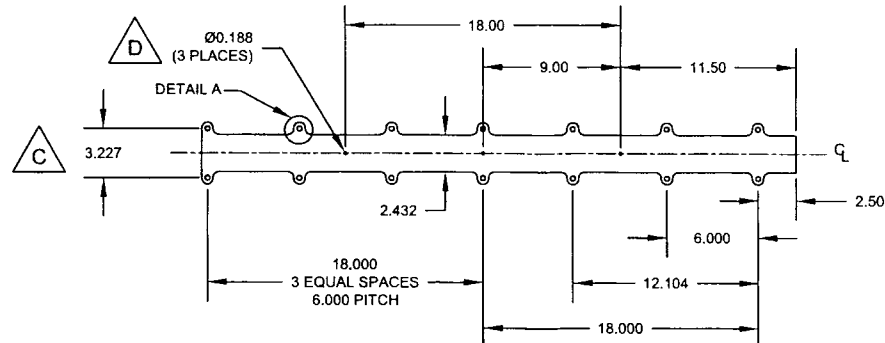
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

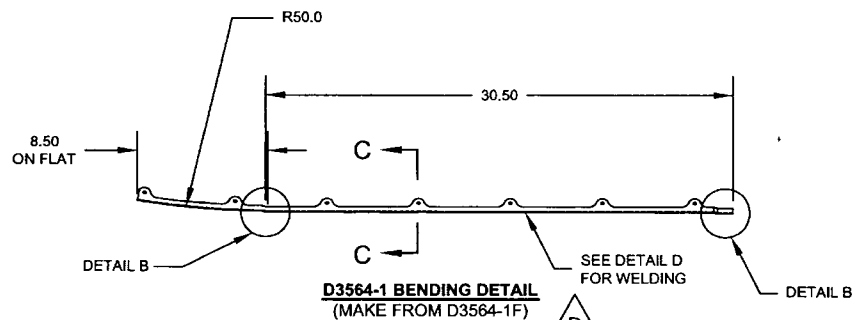
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

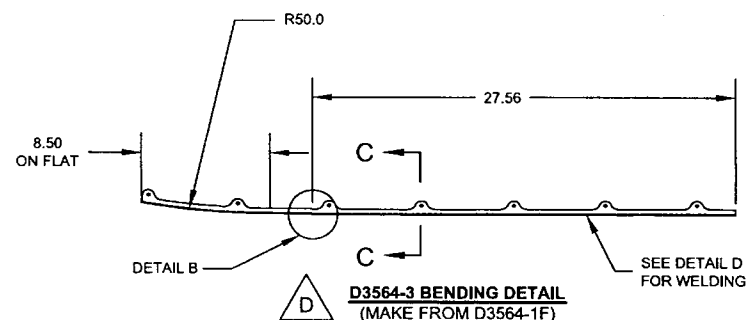
**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)**

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C-L

**WEIGHTS:**

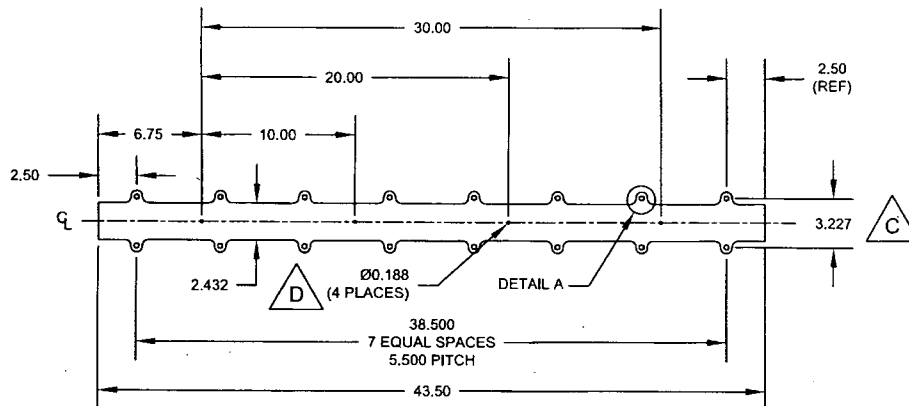
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

NO. 56111  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

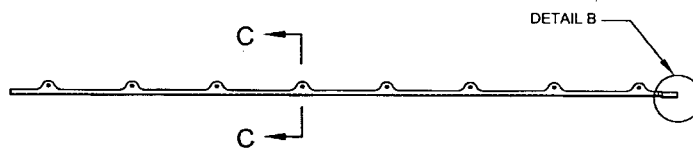
**RELEASED**

07.09.04

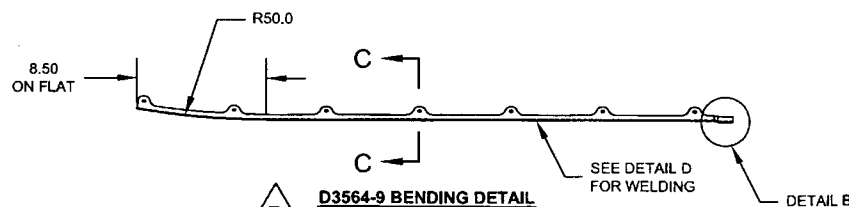
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



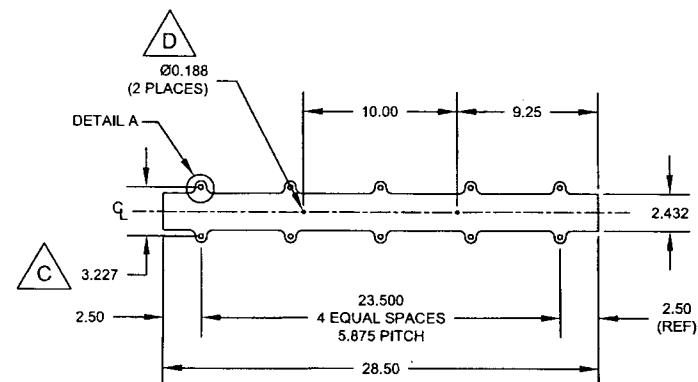
**D3564-5F FLAT PATTERN**



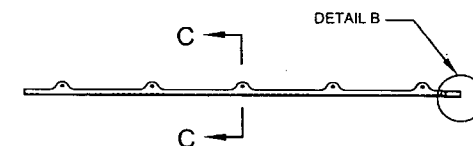
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



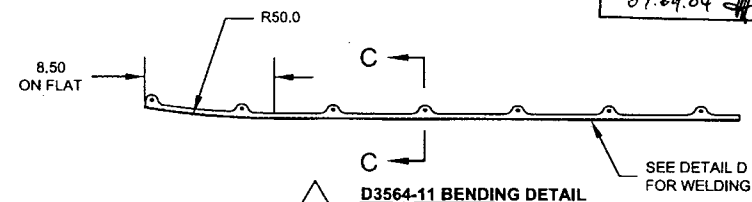
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

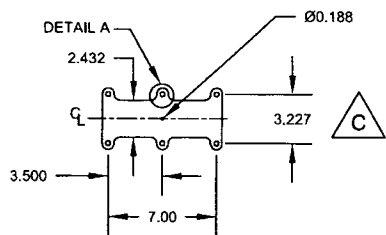
RELEASED

07.09.04

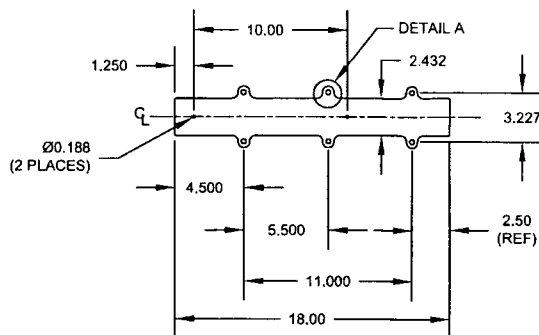
NO. 36111  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	C.B.		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

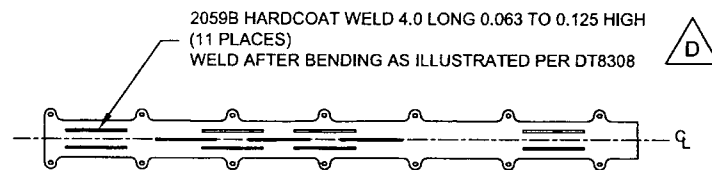
8 7 6 5 4 3 2 1



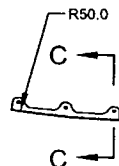
**D3564-13F FLAT PATTERN**



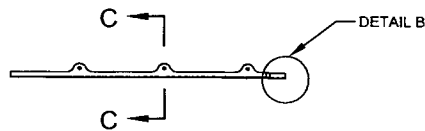
**D3564-15F FLAT PATTERN**



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



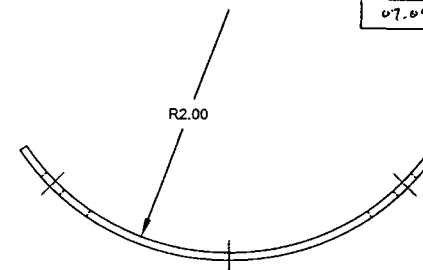
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



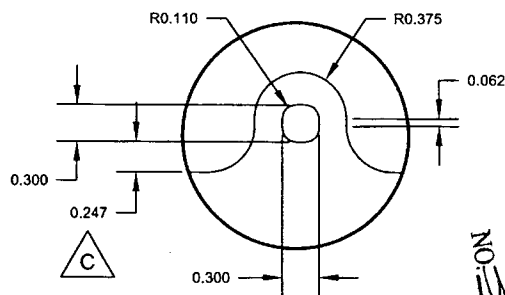
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

**RELEASED**

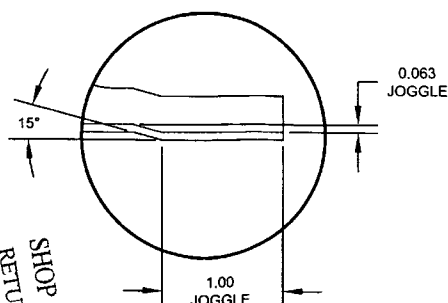
07.09.04



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

NO. 36117  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
DATE	07.08.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

